



HYDRAULIC UNIVERSAL HOLDING FIXTURES - INQUIRY GUIDE

All **KOSTYRKA**® Universal Workholding Systems are designed specifically for the application. To enable us to submit a quotation we must ask you for some details about sizes and working conditions.

STANDARDS

- Do you require or favor a particular diameter of the support rod?
- Do you have an existing standard for vacuum cups that we must incorporate into our system? (If ~~yes~~, please add vacuum cup drawing)

The rod diameter shall be $d =$ mm.

DENSITY

- Support units can be configured in any position. Although they can be set to very small centerline distances, this space naturally is limited. Please state:

The desired minimum centerline distance is mm.

BED SIZE

- What is the proposed bed size of this system and how many units are proposed?

X = m (or ft.)
(circle one)

Y = m (or ft.)
(circle one)

Quantity:

STROKE

- The available stroke ranges between 100 and 1000 mm (4" . 40"). The stroke will have a significant influence on price and, even more important, on the overall length of each support unit housing. It should be specified to be as short as the application dictates.

The maximum stroke is $h =$ mm.

ACCURACY

- Our Universal Workholding Systems consist of a stepping motor & high precision end switch combination for exact basic ("home") position. Ball screws set the end-effectors to their predetermined levels. The required accuracy is of influence on the motor control

(resolution) and the accumulated lead error of selected ball screws. Please note, that unnecessary accuracy regulations may raise the system's price considerably. Please state the maximum position tolerance in Microns when moving the effector to a position close to its maximum extension.

The accuracy must be within \pm _____ m.

LOAD FORCES

- Support rods are designed to carry axial and radial loads caused by component weight and machining forces. Please give some estimated figures:

The maximum axial load is expected to be: _____ kg (or lbs)
(circle one)

The maximum side load will not exceed: _____ kg (or lbs)
(circle one)

STIFFNESS

- Although preloaded ball screws and bearings enable the axial clearance to be below zero, a longitudinal load may result into a (small) axially movement if no additional break is provided. Please state the maximum tolerated inward movement in Microns under maximal vertical load.

The maximum inward deflection must not exceed: _____ m.

- Are you able to give a statement on the radial stiffness? What is the maximum permissible deflection of the extended support rod at maximum radial load?

The maximum radial deflection must not exceed: _____ m.

ENVIRONMENT

- For possible precautions protecting the system against dirt, chips, debris or cutting fluids we need details about the material being machined. Are honeycomb panels involved? What kind of cutting fluids do you use, if any?

Your remarks:

Í DUCKINGÍ

- Did you require a "duck-out-of-the-way" option?

Your remarks:

CONTROLLER

- Normally we combine up to 8 controllers in one standard 19" rack. Not included is the 24V power source. If you have an interface requirement for this project, please inform us.

Your remarks:

GENERAL NOTE

Our Universal Workholding Systems in their self-contained, plug'n play unit design, bear a 9-pin male connector (one cable only!) matching a plug socket in the base plate as well as a short pipe connection inserted into a bore for the vacuum supply. The support unit housing itself is secured by means of four socket head screws to the upper plate. It may be changed from the top, even in a very congested configuration.

This Inquiry guide serves to provide us with the minimum basic information to perform a budgetary proposal. It does not replace a personal meeting to discuss these and additional points in greater details.

FOR FURTHER INFORMATION PLEASE CONTACT:

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